

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001361**Date Inspected:** 26-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi, Ye Yong Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89 & OBG Mock-Up**Summary of Items Observed:**

General

This Quality Assurance Inspector oversaw Quality Assurance Inspectors Paul Stovall, Scott Croff and Joe Lanz performing fabrication inspection out on the shop floor today.

Mr. Stovall wrote a TL-15 for groove welds being improper on the 77 Meter Mock-Up between two of the skin plates. The measured angle of the fit up was 55°-57° for the OD and 30° for the ID. Angles were supposed to be OD 60° and ID 45°.

Mr. Lanz wrote a TL-15 incident report for Zhenhua Port Machinery Companies (ZPMC) failure to record shield metal arc welding variables for tack welding of stiffener plates to a floor beam plate. Mr. Lanz further reported that the area requested several days ago to be flush ground due to a near surface ultrasonic indication being found by quality assurance was still no ground and nothing had been done in the way of excavation on the ultrasonic rejected indication found by quality assurance several days prior to that.

Mr. Croff observed tack welding of assorted stiffeners on four different side plates in bay 3 and fillet welding with automated flux core arc welding on several welds on one of the bottom plates.

OBG Production

This Quality Assurance Inspector observed the temporary storage area outside where completed bottom plates

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have been moved from bay 3. The storage area is located north of the fabrication building near the new fabrication building. Bottom plates are stacked upon one another and covered with plastic tarps.

This Quality Assurance Inspector observed marking and preheating of stiffener to floor beam plates for tack welding. The Zenhua Port Machinery Company (ZPMC) welder was Ren Jin Zhu, welder identification 044837 and the ZPMC Quality Control personnel on hand was Xu Tao. No Certified Welding Inspector was present at the time. Welding was not started prior to this Quality Assurance Inspector being need else where.

### 89 Meter Mock-Up

This Quality Assurance Inspector observed ZPMC welder , welder identification 037780 welding on MUSB-MA22-14 Skin Plate D. The CWI was Mr. Sha Zhi & Ye Yong Jun. Welding parameters observed where as follows; voltage 23, amperage 228, preheat 185° Celsius and travel speed 126 millimeters per minute with the shield metal arc welding process.



### Summary of Conversations:

No conversations held today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Berger,Bruce

Quality Assurance Inspector

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**Reviewed By:** Cochran,Jim

QA Reviewer